

content of fines on one side respectively;

a couching zone in which the at least two layers are couched together such that each layer's side having a higher content of fines contact each other, wherein at least one of the at least two formers comprises at least one gap former including two circulating continuous dewatering belts convergently arranged to form a headbox nip, and in which said dewatering belts are guided in an area of said headbox nip over a forming element; and

a headbox arranged to supply a fibrous suspension to said headbox nip,

wherein said at least one gap former comprises a first gap former and a second gap former arranged to form at least two layers, wherein the higher content of fines side of said at least two layers occurs on a forming element side, and the web travel directions of said first and second gap formers are opposite each other, and

wherein a first layer created in said first gap former is guided together with at least one of said two dewatering belts around a deflection element, and then introduced via a continuous belt, traveling in a generally opposite direction to a stream direction of said headbox, into said couching zone in which the first layer and a second layer formed by said second gap former are couched together so that their sides having a higher content of fines come into contact with each other.

81. (Amended) A process for the production of a multi-layered fibrous web, comprising:

forming at least two layers via at least two formers, such that each layer has a side with a higher fines content;

couching together the at least two layers in a couching zone so that the sides with higher fines content contact each other;

wherein at least one of the at least two layers is formed by at least one gap former comprising two circulating continuous dewatering belts that run together forming a headbox nip and which are guided in the area of the headbox nip, loaded with a fibrous suspension by a headbox, over a forming element,

wherein the at least one gap former comprises a first gap former and a second gap former arranged to form at least two layers, wherein the higher content of fines side of said at least two layers occurs on a forming element side, and the first and second gap formers are operated in opposite web travel directions, and

wherein a first layer formed in the first gap former is guided together with at least one of the two dewatering belts around a deflection element, and then via a continuous belt is introduced in a direction generally opposite to the travel direction of a first headbox into the couching zone in which the first layer and a second layer formed by the second gap former are couched together so that their sides having a higher content of fines come into contact with each other.